

Slip 09/09

Date: Tuesday, 8/28/2007 3:17:28 PM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT BRACKET  
Job Number : 34292  
Estimate Number : 10260  
P.O. Number : N/A Part Number : D23623  
This Issue : 8/28/2007 S.O. No. : N/A Drawing Number : D2362 REV E1  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : MACHINED PARTS Drawing Revision : E1  
Previous Run : 31503 Material : N/A  
Written By : Due Date : 9/7/2007 Qty: 6 Um: Each  
Checked & Approved By : 07.08.28  
Comment : Est: G 80.05.18 Added inspection level 8 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2265 Step Support Casting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Step Support  
Pick:

Qty Part Number Description  
1 D2265 Step Support

Batch 79807 W 570829

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Machine per folio D2362-3

07/09/02 (6)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: Inspect Level 2

07/09/02 (6)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/09/03 (6)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

07/09/02 (6)

6.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

M 105 068 07-09-04

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/28/2007 3:17:28 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 34292

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

mf 02-09-04

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B30971

mf 07-09-05

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B30972

mf 07-09-05

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement  
as per Dwg D2362

Batch M102805

mf 07-09-05

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/09/05 (6)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 481

Ca 7/9/05

(6)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

En 07/09/05 (6)

Job Completion



u 07-09-05

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**



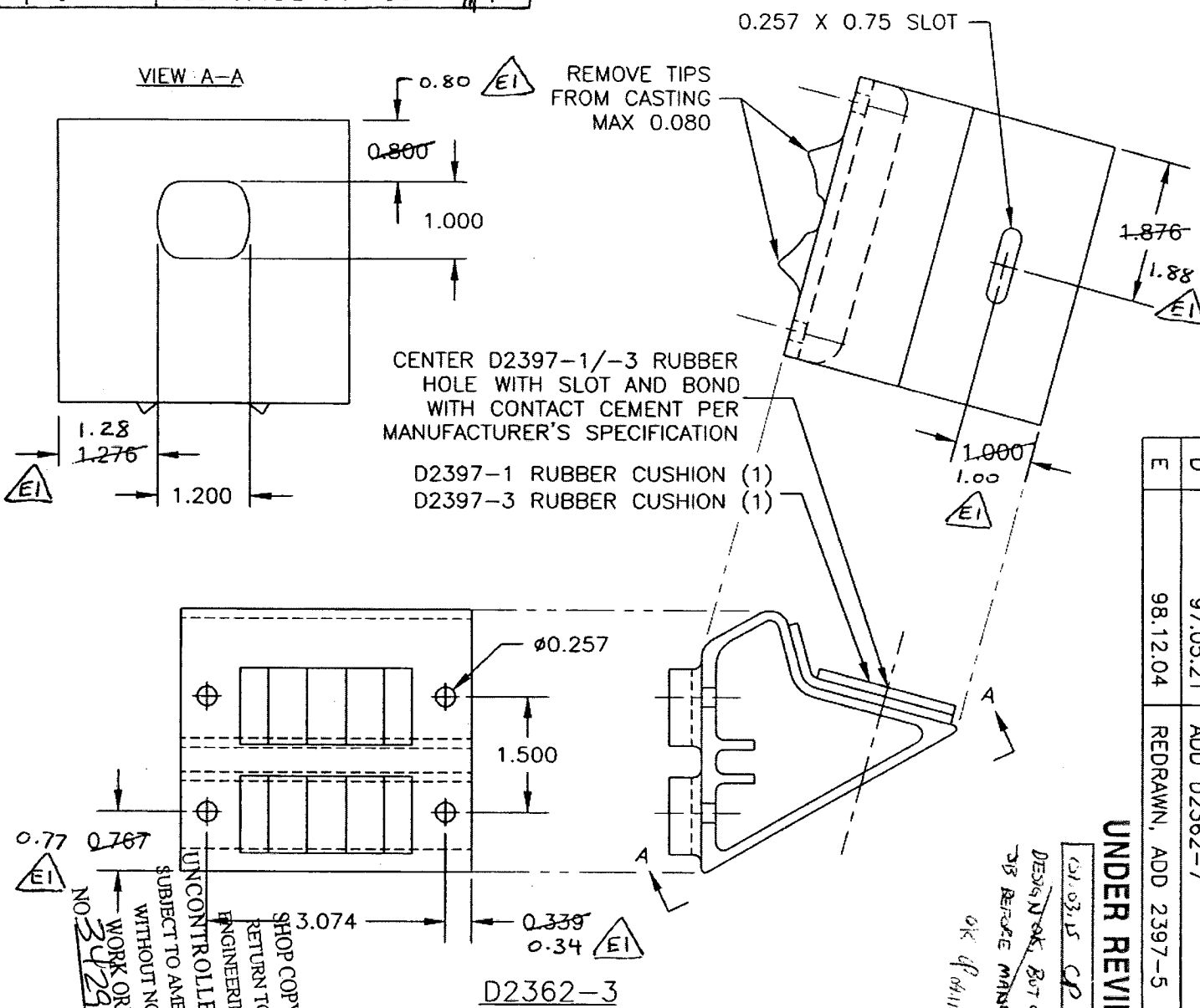
**RELEASED**  
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	<i>CP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>#</i>	DRAWING NO. D2362
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	REV. E SHEET 1 OF 3
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

**UNDER REVIEW**

01.03.15 CP

DESIGN OK, BUT CHECK WITH  
35 BEFORE MANUFACTURE  
OK 01/11/05



**NOTES:**  
MAKE FROM D2362  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 34292

**DART**



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.04	DRAWING NO.	D2362	REV. E
TITLE	STEP SUPPORT BRACKET	SHEET 2 OF 3	SCALE	1:2

**RELEASED**  
98.12.14 KE  
**UNDER REVIEW**

CHG 05 CP

DESIGN OK, BUT CHECK BY  
DB BEING MANUFACTURE  
OK 09.1.05

MACHINE TO  
R1.100  
(TYP 2 PLACES)

REMOVE TIPS  
FROM CASTING  
MAX 0.080

0.257 X 0.75 SLOT

VIEW A-A

1.500 1.50

1.876  
1.88

Ø0.257 0.100  
R16.680

1.500

0.339

BLACK ANTI-SKID PAINT FOR D2362-1  
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

0.77 0.767  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
NO. 2122  
WORK ORDER  
WITHOUT NOTICE

NOTES:

MAKE FROM D22065

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT

AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.04	DRAWING NO.	D2362	REV. E
TITLE	STEP SUPPORT BRACKET	SHEET	3 OF 3	SCALE
				1:2

UNDER REVIEW

01.03.15 CP

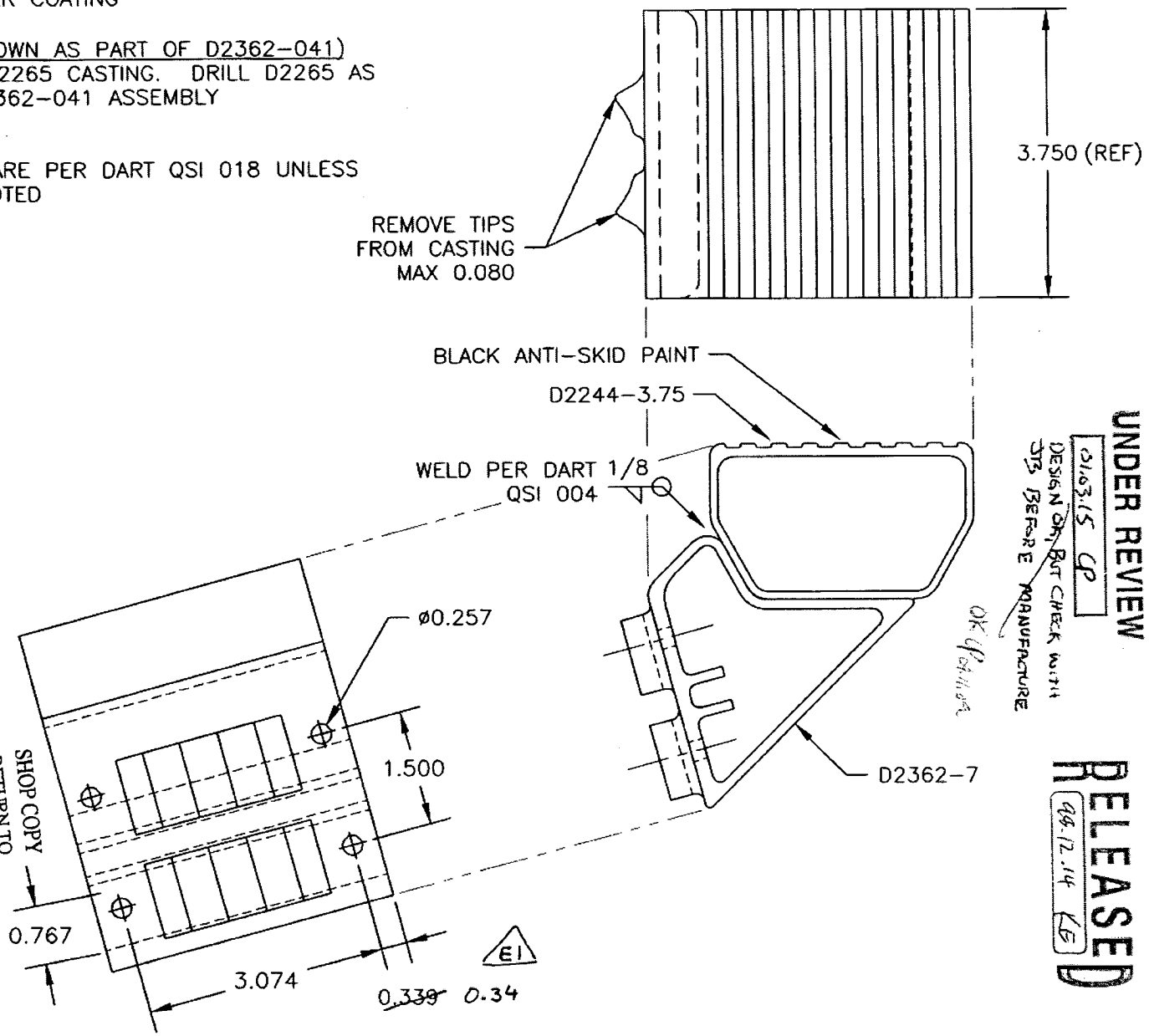
DESIGN OK BUT CHECK WITH  
JTS BEFORE MANUFACTURE

RELEASED  
98.12.14 KE

D2362-041 (SHOWN)  
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER  
QSI 005 4.3  
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER  
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)  
MAKE FROM D2265 CASTING. DRILL D2265 AS  
SHOWN IN D2362-041 ASSEMBLY

NOTES:  
TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



Copyright 1995 by DART AEROSPACE LTD

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
342292



[illegible]